

These installation instructions are for informational purposes only. Phase 5 recommends all installations be done by a qualified gunsmith.

The installation procedure for the Phase 5 REVO (Revolving Sling Attachment Solution) is the same as a standard End Plate with the only difference being the torque specification of 25 (+/- 2) FTlbs.

Included:

- REVO Sling Attachment
- Castle Nut

Tools required:

- Torque wrench
- Armorer's [wrench](#)
- Vise
- Sturdy lower receiver vise block
- Castle Nut Staking Tool
- Safety glasses

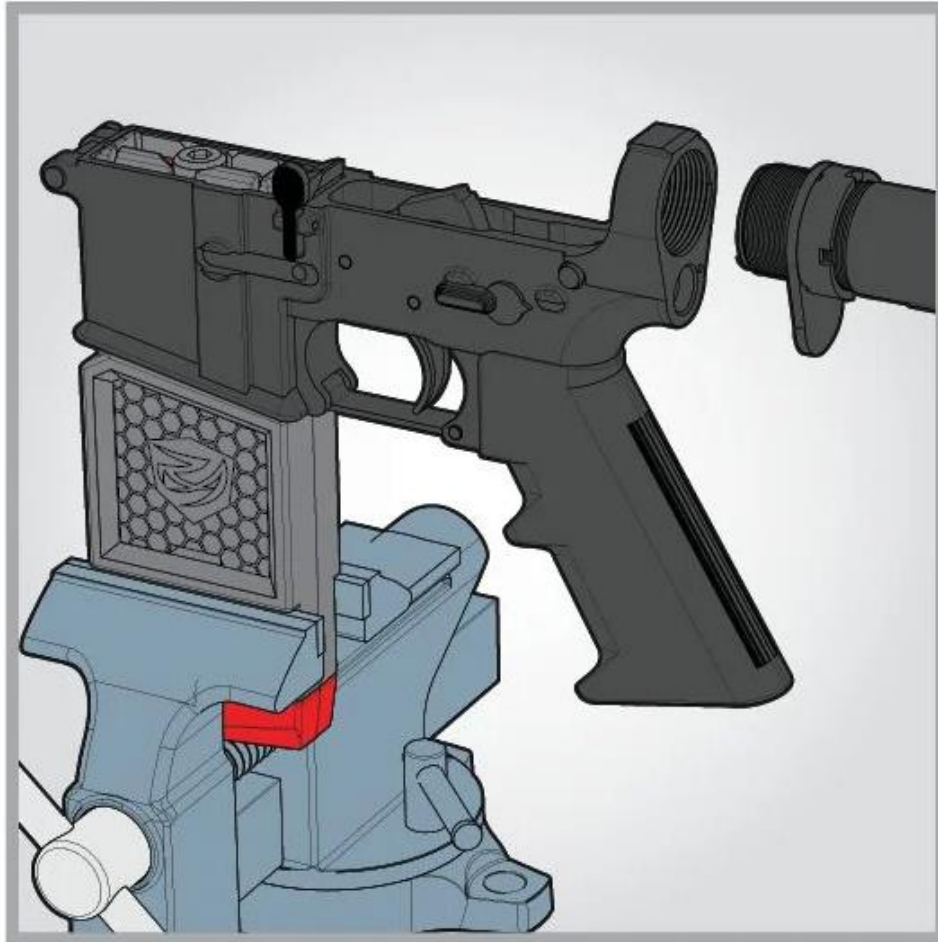
Before starting any installation process, make sure to follow all basic safety rules and make sure the weapon is clear of any magazines or ammunition. Clear your workspace of any unneeded clutter and wear safety glasses.

- 1) **Disassemble and Mount:** remove the upper receiver and mount the lower assembly onto the lower receiver vise block clamped in a vise.

- 2) **Remove Buffer and Spring:** remove the buffer and buffer spring from the buffer tube by pressing down on the Buffer Retainer Pin.
 - a. Reminder: buffer and spring are under pressure! Use caution when removing the buffer and spring combo.



- 3) **Remove Buffer Tube:** using the Armorer's wrench, loosen the castle nut. Thread the castle nut all the way onto the tube and move the end plate away from the lower receiver.
 - a. Reminder: the Takedown Pin's spring and detent are behind the End Plate.



- 4) **Exchange Standard Components with REVO Components:** remove the End Plate and Castle Nut from the buffer tube. Install the provided REVO Castle Nut, threading it all the way onto the tube. Install the REVO sling attachment by simply sliding the part onto the buffer tube, aligning the notch at the bottom with the channel on the buffer tube.
- 5) **Reinstall Buffer Tube:** if removed, reinstall the Takedown Pin detent/spring combo and the Buffer Retainer/spring combo. While pressing down on the Buffer Retainer, thread the buffer tube back into the lower receiver until the front of the tube captures the Buffer Retainer, making sure the bottom of the REVO is at the 6 o'clock position.

- 6) **Install REVO:** push the REVO forward to the lower receiver, making sure to capture the Takedown Pin's spring behind it. Tighten the Castle Nut to hand tight, then use an Armorer's Wrench to torque the Castle Nut to 25 (+/- 2) FTlbs.
- a. **Please note that over torquing the Castle Nut can cause the swivel of the REVO to lock into place or possibly rotate past the internal stopping point.** Once installed, verify functionality by testing the movement of the swivel. The swivel should move a total of 120-degrees, 60-degrees to each side.



- 7) **Castle Nut Staking:** Phase 5 WSI recommends staking the Castle Nut once the REVO has been installed and function has been verified.
- a. Make sure that no material is forced into the REVO swivel while staking the Castle Nut as this will cause movement issues with the swivel.



- 8) **Reinstall Buffer and Buffer Spring:** install the buffer and spring into the Buffer Tube, making sure that the face of the buffer has past and is contacting the Buffer Retainer.



- 9) **Reassemble and Function Test:** reinstall the upper receiver onto the lower receiver and perform a basic function/safety test of the weapon system prior to any live fire.